

Work Order ID 62941

October 14, 2010 11:11:08 AM



Page 1

Item ID: D350-602-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Pod, LH

Start Date: 10/14/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/20/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9515	B

D2202 Rev. 6 10.10.29

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-602-013

CHG002

8/10/10/17

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON. CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D350-602-011	CHG	CHG006		
DESC.	Heli-Utility-Pod	STC	SH93-97		
LOT	B61170	STC	SR01144NY		
MODEL	AS350	STC			
MADE IN CANADA					
D2729-1					

Work Order ID 62941

Page 2

October 14, 2010 11:11:08 AM

Item ID: D350-602-013

Accept



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Stop



Item Name: Heli-Utility-Pod, LH

Start Date: 10/14/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/20/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____


Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	PULL FROM STOCK: 1 X D350-602-011 B <u>61170</u> MODIFY PER DEO 9217 1-Assemble as per Dwg D2694 2-Install label D2258-160 on Pod Assembly as per Dwg D2694 at location of max pod load label on pg2 of dwg 3-Modify as per DEO 9217 INSTALL 1 X D3048-1 B <u>52263</u> W/ 46 X AD64ABS B <u>108712</u> w/ 3 x MS24693-S273 B <u>N/A</u> EPOCAST 50A/B B <u>115154</u> HADENER 9816 B <u>115154</u> 90Z CLOTH B <u>113905</u> PRIMER FILLER B <u>114823</u> ACTIVATOR B <u>114823</u> RTV SEALANT B <u>112857</u>								

RT 10-10-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.10.29	140	Assemble per D2202 Rev. 6 Acceptable to use all AD64ABS RIVETS.	ET	10-10-29	1	CP 10.10.29 051042	S 10/10/29

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62941

October 14, 2010 11:11:09 AM



Page 3

Item ID: D350-602-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Pod, LH

Start Date: 10/14/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/20/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/10/29

(40)

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

ensure kit is complete

Perkins ①

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/10/29

(40)

Work Order ID 62941

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Item ID: D350-602-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Pod, LH

Start Date: 10/14/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/20/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Packaging	Packaging	0.00							
Packaging	Memo RE-PACKAGE- PPP D350-602-013 USING NEW B/N NEW LABELS REQUIRED Location: <u>180</u> PPP Rev: <u>B</u>	0.00							
190 QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

10/10/29

10-10-29

10-10-29

Picklist Print

Page 1

October 14, 2010 11:11:07 AM

Work Order ID: 62941

Parent Item: D350-602-013

Parent Item Name: Heli-Utility-Pod, LH




Start Date: 10/14/10

Required Date: 10/20/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-05-01 JLM IPP Rev:B Added D3495-1 06-05-17
JLM IPP RevC: add route seq DD 10.01.07 verified
by:EC IPP REV:D AS PER ECN 10-558 JLM 10-04-27
VERIFIED BY:DD
IPP Rev:C 09-02-03 update dwg rev's DD verified by:EC IPP Rev:D
add D2202-1 and D2202-5 DD 10.04.07 verified:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AD64ABS  Pop Rivets		Purchased	No				Each	240.0000		48 x 44 RT 10-10-29			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST281		240							
				108712		240				x 44			
D3048-1  Doubler		Manufactured	No				Each	5.0000		1 RT 10-10-29			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		5				x 1			
				52263		5				1			
D350-602-011  Heli-Utility-Pod (LH/RH)		Manufactured	No				Each	2.0000		1 RT 10-10-29			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG104		2							
				52427		1							
				61170		1				x 1			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

October 14, 2010 11:11:07 AM

Work Order ID: 62941



Parent Item: D350-602-013



Parent Item Name: Heli-Utility-Pod, LH

Start Date: 10/14/10

Required Date: 10/20/10

Start Qty: 1.00

Required Qty: 1.00

FG-778150-550-ROL

Purchased

No

sf

1,901.750

1.



8 10-10-29

7781 9oz Glass 50"x125yd

Location

Loc Qty

Loc Code

ST404

1901.75

108932

18

111166

399

113905

1484.75

XC

MS24693-S272

Purchased

No

Each

221.0000

3



Screw

Location

Loc Qty

Loc Code

ST288

221

111548

1

112492

120

115835

100

NOT REQ'D

PER W/D CDA

CP 10.10.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED S	APPROVED S	DRAWING NO. DEO 9217	REV. A SHEET 1 OF 1
DATE 01.09.26		TITLE MOsaic POD MODIFICATION	
A	01.09.26	NEW ISSUE	

DART ENGINEERING ORDER

TO AMEND D2202 REV. F

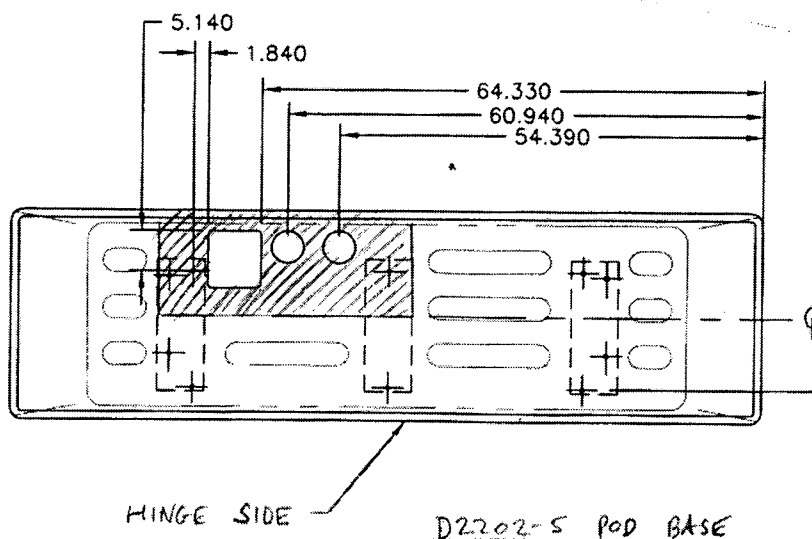
TO MAKE A D2202-S BASE (FOR D350-602-013) FROM A D2202-3 BASE :

- 1) REMOVE FOAM IN SHADED AREA OF POD.
- 2) FILL GAPS WITH 902 SATIN AND RESIN PER DWG (APPROX. 3-4 LAYER)
- 3) 2 LAYERS OF 902 SATIN
- 4) INSTALL D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) INSTALL DOUBLER WITH AD64ABS RIVETS (46) AND MS246935212 SCREWS (3)
- 6) CUT HOLES AND SEAL WITH CYANOACRYLATE GLUE
- 7) TOUCH UP SPACKLE GREY FINISH AND CLEARCOAT

Wlo 62941

RELEASED

04.10.14 H



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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-602 REV E (OR EARLIER REV.)
AND INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D350-602 REV. 0

REF. TCCA STC: SH93-97

REF. FAA STC: SR01144NY

REF. EASA STC: EASA.IM.R.S.01290

PURPOSE

Dart Heli-Utility-Pods D350-602-011 @ CHG 006 and D350-602-013/-014 @ CHG 002 have new attachment lugs.

CHANGE

The D2230-1/-3 clamps are replaced with wider D4091-1/D3910-3 lugs. The abrasion strip is replaced with D3984-030 rubber extrusion. The D2462-1700 Neoprene Seal is replaced with D2461-1700 Neoprene 'D' Seal. The modified parts list for Installation Instruction D350-602 and Instructions for Continued Airworthiness ICA-D350-602 is shown on sheet 2 of this service instruction. Install the lugs as shown in Figure 1 & 2 of this service instruction. The pod should otherwise be installed per D350-602 and maintained per ICA-D350-602.

The weight and balance for Dart Heli-Utility-Pods D350-602-011 @ CHG 006 and D350-602-013/-014 @ CHG 002 (or later) are updated as follows:

5.0 WEIGHT AND BALANCE (D350-602 Rev. E)

25.6 WEIGHT AND BALANCE (ICA-D350-602 Rev. 0)

The following weight and balance information is for the Dart *Heli-Utility-Pod™*. The weight and balance of any parts that are removed from the aircraft to perform this installation or equipment installed/stowed in the pods are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-602-011 @ CHG 006	61.2 lb	±51.0 in	±3121 in-lb	135 in	8262 in-lb
Heli-Utility-Pod™ LH or RH	27.8 kg	±1.29 m	±35.9 m-kG	3.43 m	95.4 m-kG
D350-602-013 @ CHG 002	61.2 lb	-51.0 in	-3121 in-lb	135 in	6872 in-lb
Heli-Utility-Pod™ LH	27.8 kg	-1.29 m	-35.9 m-kG	3.43 m	79.2 m-kG
D350-602-014 @ CHG 002	61.2 lb	+51.0 in	+3121 in-lb	135 in	6872 in-lb
Heli-Utility-Pod™ RH	27.8 kg	+1.29 m	+35.9 m-kG	3.43 m	79.2 m-kG

LUG UPGRADE KIT

The Dart DSI-9515-011 kit is available to upgrade D350-602-XXX Heli-Utility-Pods made to earlier change numbers with D4091-1 / D3910-3 lugs. The lugs should be installed per Figure 1 & 2 of this service instruction.






QTY -011	Part Number	Description
X	DSI-9515-011	LUG UPGRADE KIT
4	D4091-1	LUG
4	D3910-3	LUG
8	D3984-030	RUBBER EXTRUSION
16	AN4-14A	BOLT
32	AN960JD416	WASHER (OR NAS1149DO463J)
16	MS21042L4	NUT (OR MS21042-4)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.04.23
CERT. NO.: SH93-97
ISSUE NO.: 4

B	NAS1149DO463J WAS xDN432J & CHG QTY	CP	10.04.23
A	NEW ISSUE	CP	10.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9515	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG MODIFICATION	NTS
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6.0 PART LIST (D350-602 Rev. E)
25.7 PARTS LIST (ICA-D350-602 Rev. 0)

Qty D350-602 -011	Qty D350-602 -013	Qty D350-602 -014	Qty DSI9052 -013	Part Number	Description
X				D350-602-011	HELI-UTILITY-POD™ (FITS BOTH LH/ RH)
	X			D350-602-013	HELI-UTILITY-POD™, LH
		X		D350-602-014	HELI-UTILITY-POD™, RH
			X	DSI9052-013	QUICK RELEASE KIT
1				D2694	POD ASSEMBLY (LH OR RH)
	1			D3322-041	POD ASSEMBLY (LH)
		1		D3322-042	POD ASSEMBLY (RH)
1	1	1		*D2202-1	POD LID
1				*D2202-3	POD BASE
	1	1		*D2202-5	POD BASE
5	5	5		*D2204-9	LATCH
1	1	1		*D2429-041	SPRING CLIP ASSEMBLY
1	1	1		*D2461-1700	NEOPRENE 'D' SEAL
5	5	5		*D2528-1	BACKER PLATE
4	4	4		*D2528-3	BACKER PLATE
1	1	1		*D2569	HINGE
1	1	1		*D3007-041	PROP ASSEMBLY
1	1	1		** D2012-107	CLEVIS
2	2	2		** D2022-101	SPACER
1	1	1		** D2705	SUPPORT BRACKET
1	1	1		** D3007-1	STRUT
1	1	1		** D3015-3	LOCKNUT
1	1	1		** AN4-10A	BOLT
1	1	1		** AN960JD416	WASHER
1	1	1		** MS21042L4	NUT (OR MS21042-4)
1	1	1		** SL69-BS	BALL STUD
1	1	1		** AN960JD516	WASHER
19	19	19		AN4-5A	BOLT
1	1	1		AN4-6A	BOLT
2	2	2		AN526C632R7	SCREW
21	21	21		AN960JD416	WASHER
2	2	2		AN960JD6	WASHER
2	2	2		MS21042L06	NUT (OR MS21042-06)
20	20	20		MS21042L4	NUT (OR MS21042-4)
4	4	4		D4091-1	LUG
4	4	4		D3910-3	LUG
1	1	1		D2258-160	LABEL
1	1	1		D2324-1	STRUT ASSEMBLY
2	2	2		D2523	MOUNTING BRACKET
2	2	2		D2524	SIDE PLATE
1	1	1		D3495-1	PLACARD
8	8	8		D3984-030	RUBBER EXTRUSION
4	4	4		AN3-7A	BOLT
8	8	8		AN3-15A	BOLT
1	1	1		AN4-12A	BOLT
16	16	16		AN4-14A	BOLT
4	4	4		AN4-16A	BOLT
24	24	24		AN960JD10	WASHER
42	42	42		AN960JD416	WASHER
12	12	12		MS21042L3	NUT (OR MS21042-3)
21	21	21		MS21042L4	NUT (OR MS21042-4)
			1	BLRS-010	QUICK RELEASE PIN (1" GRIP)
			3	BLRS-020	QUICK RELEASE PIN (1.5" GRIP)





* INCLUDED IN D2694 OR D3322-041/-042 POD ASSEMBLIES LISTED ABOVE

** INCLUDED IN D3007-041 PROP ASSEMBLY LISTED ABOVE

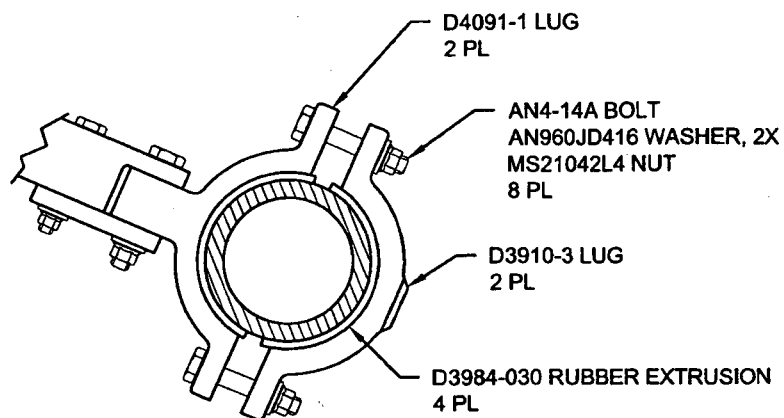
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 10.04.23
CERT. NO.: SH93-97
ISSUE NO.: 4

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9515	SHEET 2 OF 4
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62441



SECTION X-X
NOT TO SCALE

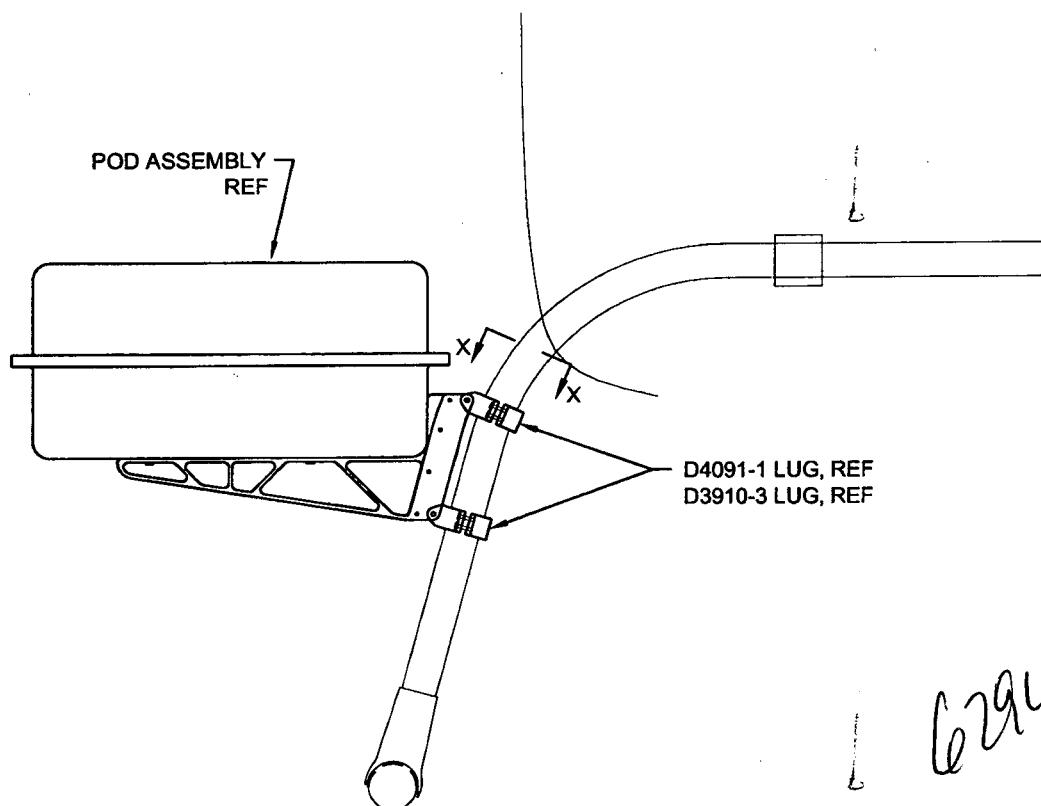







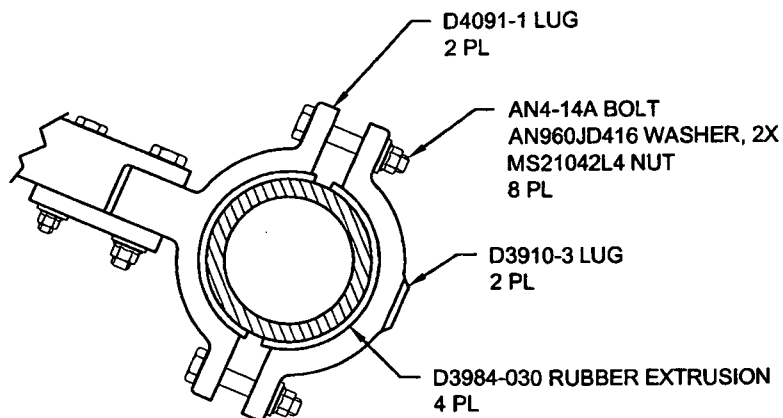
FIGURE 1: Aft Crosstube Attachment
(Installation of D4091-1 / D3910-3 Lugs)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.23
CERT. NO.: SH93-97
ISSUE NO.: 4

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9515	SHEET 3 OF 4
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SECTION X-X
NOT TO SCALE

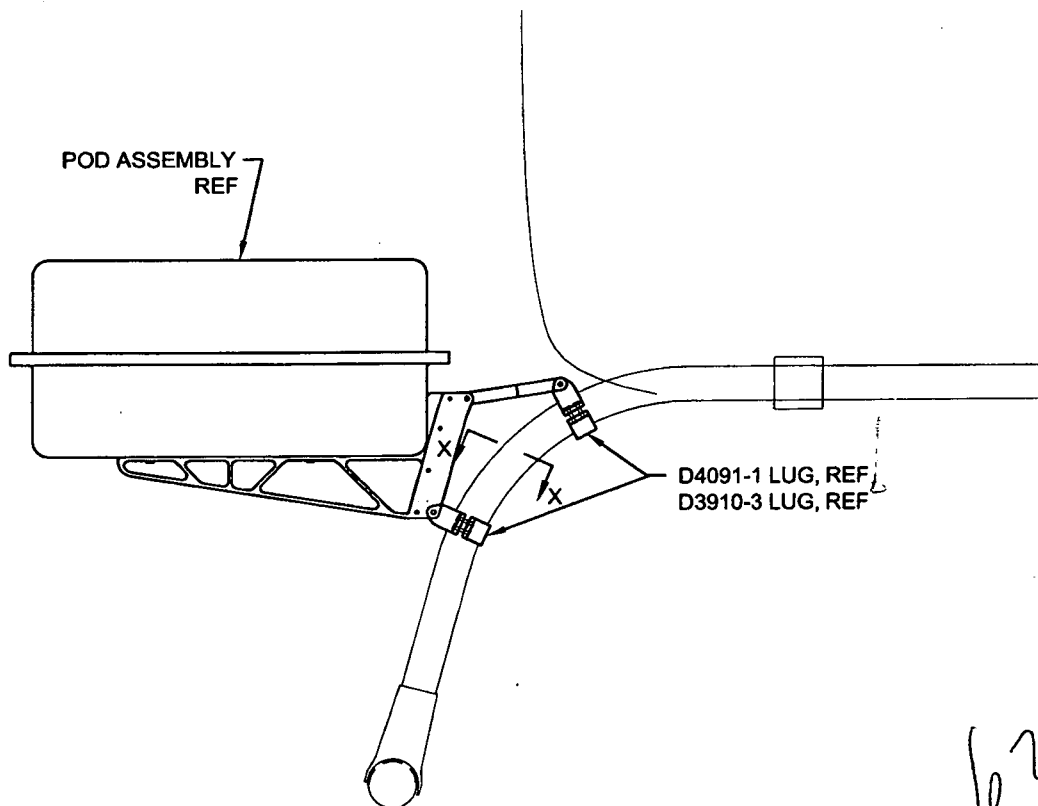


FIGURE 2: Fwd Crosstube Attachment
(Installation of D4091-1 / D3910-3 Lugs)

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	10.04.23
CERT. NO.:	SH93-97
ISSUE NO.:	4

DESIGN	<i>92</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>92</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9515	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG MODIFICATION	NTS
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NOTES:**1) MATERIALS:**

RESIN: EPOCAST 50-A/9816,
OR DERAKANE 470-36/411/510A40

FOAM: A500 CORE CELL,
OR DIVINYCELL,
OR AIREX,
0.38 THICK (3/8 FOAM)

FIBRE: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
5 oz PLAIN WEAVE KEVLAR (5 oz KEVLAR)

2) FINISH: INSIDE = PRIME PER DART QSI 005 4.2
OUTSIDE = WHITE GELCOAT #GEL 944W005

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: N/A

8) LAMINATE PER DART QSI 006.
LAMINATION SCHEDULE PER THIS DRAWING.

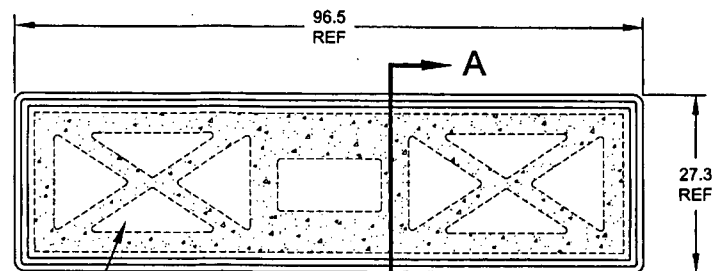
9) PEEL PLY ALL SURFACES.

RELEASED
2010-10-28
MD

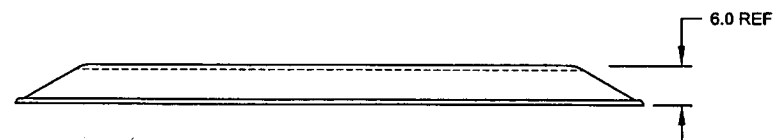
G	REFORMAT DRAWING TO CURRENT STANDARDS; D2202-101 WAS D2202-1 (ZN C5-2, A4-2); ADD 77.5 & 22.0 DIM. (ZN D4-3, C6-3); D2202-103 WAS D2202-5 (ZN C5-3, A4-3); ADD 2.00 MAX (ZN D3-4); INCORPORATED DEO 9217 & ADD D2202-5/-6 ON SHEET 5 PER PAR 09-034	RF	09.10.06
F	CHANGE LAYUP, DOUBLER, NOW DRILLED	CP	01.03.14
E	ADDED SECTIONS WITH LIP DIMS	KE	99.11.11
D	MOVED DOUBLERS, REMOVED HOLES	KE	98.11.09
C	REVISED DOUBLER/HOLES LOCATIONS	KE	97.07.04
B	ADD DOUBLERS AND HOLES	-	93.10.27
A	NEW ISSUE	-	93.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 1 OF 5
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SEE
DETAIL B
A6-2

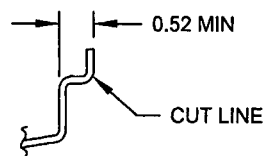
SECTION A-A C3-2



G
D2202-101 FOAM CORE,
MAKE FROM 3/8" FOAM, ROUTER PER DT8024



D2202-1 LID
(MOLD DT8002)



DETAIL B
SCALE 10X D6-2

MAIN LAYUP

G
9oz SATIN
9oz SATIN
5oz KEVLAR
D2202-101 FOAM CORE
5oz KEVLAR
9oz SATIN

RELEASED
R 2010-10-28

DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	92	DRAWING NO. D2202	REV. G
MFG. APPR.	JM	SHEET 2 OF 5	
APPROVED	119	TITLE	SCALE
DE APPR.	119	UTILITY POD LID AND BASE	NTS
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SEE
DETAIL D
87-3

SECTION C-C C4-3

ENSURE THIS
EDGE IS STRAIGHT
WITHIN 0.060"
AFTER TRIMMING

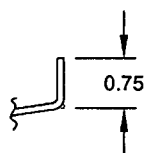


D2202-103 FOAM CORE,
MAKE FROM 3/8" FOAM, ROUTER PER DT8559

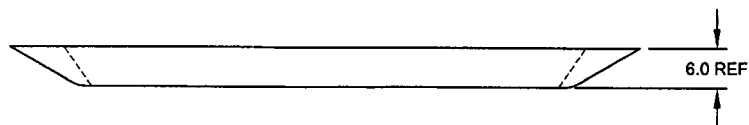


M4
DETAIL F,
HOLE LOCATION

C4-4
DETAIL E,
DOUBLER INSTALLATION



DETAIL D D7-3
SCALE 10X



D2202-3 BASE
(MOLD DT8002)

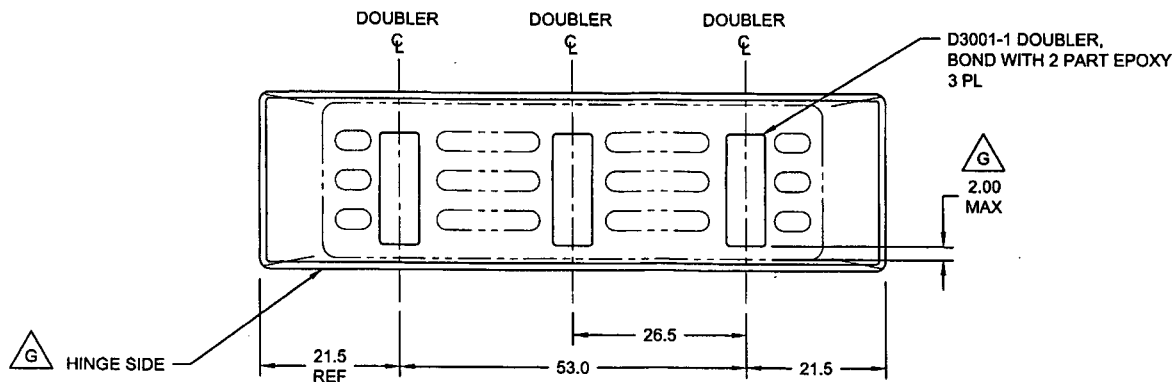
MAIN LAYUP

9oz SATIN
9oz SATIN
5oz KEVLAR
D2202-103 FOAM CORE
5oz KEVLAR
5oz KEVLAR
9oz SATIN

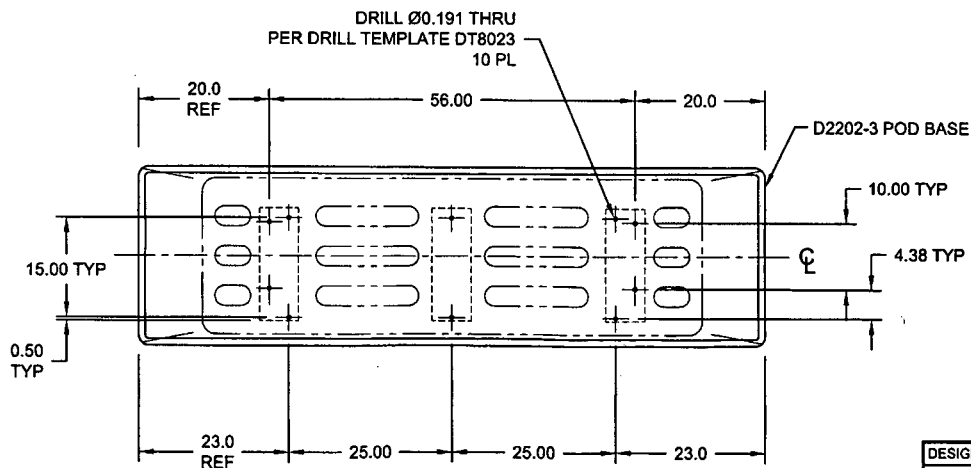


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R 2010-10-28

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 3 OF 5
APPROVED	102	TITLE	SCALE
DE APPR.	102	UTILITY POD LID AND BASE	NTS
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DETAIL E: INSTALLATION OF D3001-1 DOUBLERS C3-3



DETAIL F: HOLE DRILLING C3-3
(AFTER DOUBLER INSTALLATION)

RELEASED
2010-10-28

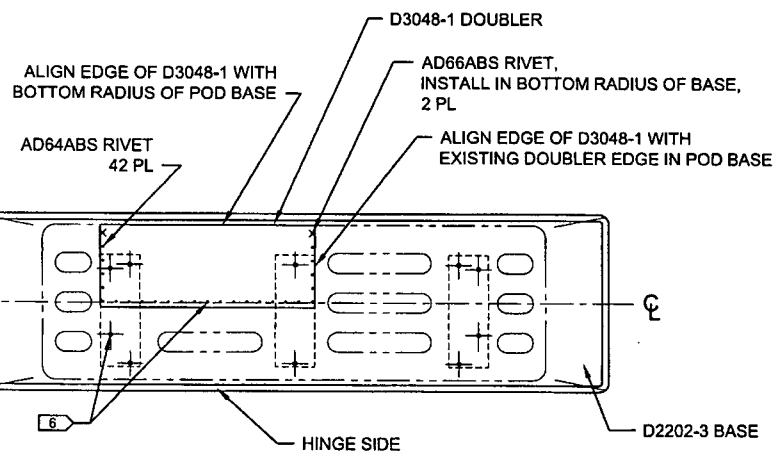
DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 4 OF 5
APPROVED	119	TITLE	SCALE
DE APPR.	119	UTILITY POD LID AND BASE	NTS
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NOTES : TO MAKE A D2202-5/6 BASE (FOR D350-602-013-014) FROM A D2202-3 BASE

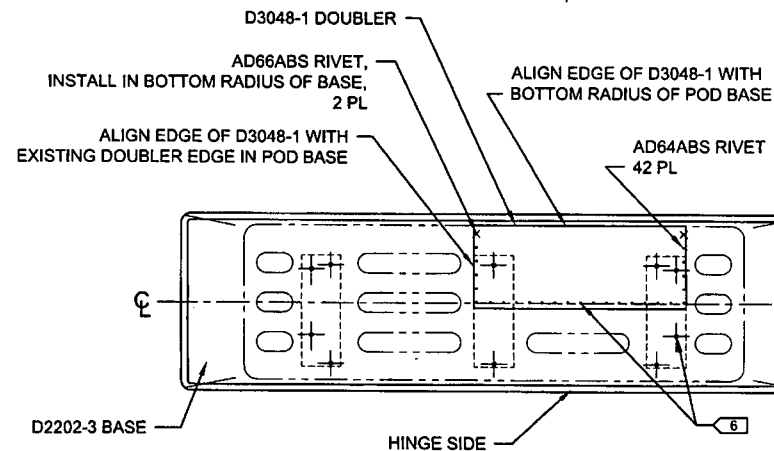
- 1) REMOVE FOAM IN AREA OF POD BASE WHERE D3048-1 DOUBLER WILL BE INSTALLED
- 2) FILL GAPS WITH 9oz SATIN AND RESIN PER DWG (APPROX. 3-4 LAYERS)
- 3) 2 LAYERS OF 9oz SATIN
- 4) BOND D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) TRANSFER Ø0.125 HOLES FROM D3048-1 TO POD BASE. INSTALL DOUBLER WITH AD64ABS RIVETS (42) AND AD66ABS (2)
- 6) TRANSFER Ø0.191 HOLES FROM POD BASE TO D3048-1. SEAL HOLES WITH CYANOACRYLATE GLUE
- 7) TOUCH UP AFFECTED AREA WITH GREY PRIMER PER DWG
- 8) FILL CENTER OF THE AD RIVETS WITH RTV 732 TO SEAL

PART LIST:

QTY -5	QTY -6	PART NUMBER	DESCRIPTION
X		D2202-5	POD BASE
	X	D2202-6	POD BASE
1	1	D2202-3	BASE
1	1	D3048-1	DOUBLER
42	42	AD64ABS	RIVET
2	2	AD66ABS	RIVET
A/R	A/R	RTV	SEALANT



D2202-5 BASE: D3048-1 DOUBLER INSTALLATION
(MAKE FROM D2202-3 BASE)



D2202-6 BASE: D3048-1 DOUBLER INSTALLATION
(MAKE FROM D2202-3 BASE)

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 5 OF 5
APPROVED	112	TITLE	SCALE
DE APPR.	112	UTILITY POD LID AND BASE	NTS
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Work Order ID 62941

October 14, 2010 11:11:08 AM

Accept

Setup Start

Stop

Item ID: D350-602-013

Revision ID:

Item Name: Heli-Utility-Pod, LH

Start Date: 10/14/10 Start Qty: 1.00

Required Date: 10/20/10 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI 9515

B

D2202 Rev. 6 10.10.29

0.00

100

DOCUMENT CONTROL

0.00

DC

Memo

Photocopy bluefile & type labels per PPP D350-602-013

CHG002

Document Control

DART				TC APPROVAL # 09-89	
Dart Aerospace Ltd.				TEL: 1-613-632-5200	
1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7					
P/N	D350-602-011	CHG	CHG006		
DESC.	Heli-Utility-Pod	STC	SH93-97		
LOT	B61170	STC	SR01144NY		
MODEL	AS350	STC			
MADE IN CANADA					
D2729-1					